

Work Order ID 73526

Thursday, September 01, 2011 2:41:18 PM

Page 1

Item ID: D3910-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Lug

Start Date: 9/1/2011 Start Qty: 30.00

Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3910

B

100

0.00

Bandsaw

Jeaspa Bandsaw

~~Memo~~

Cut to 1.450" Long

0.00

Cut @ meter

110

0.00

HAAS 1

HAAS CNC vertical machine #1

~~Memo~~

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: _____

DWG REV: _____

DEBURR

issue R/O to meter

R/O: 14799

CY 11/09/01 30

CY 11/09/01 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd + inspect for transit damage.
attached c of c to w/o

130



QC

Quality Control

QC3- Inspect parts - second check

0.00

Memo

0.00

8 w/o 11/2

count
x30

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

30 BR 11-9-13.

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

Start Time: 2:30
Temp: 320°F
Finish Time: 3:00

30x4 m-11/09/13

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

30 coats of 22 11/09/13

170

Identify as per dwg & Stock Location 507

0.00

Packaging

Memo

0.00

Packaging

30x

11-09-14

W/O:		WORK ORDER CHANGES					
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Page 4

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Customer:

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Run Start



Approvals:

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14

CL11109104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Thursday, September 01, 2011 2:41:15 PM

Page 1

Work Order ID: 73526

Parent Item: D3910-3

Parent Item Name: Crosstube Lug



Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	538.5000	0.13	4.105263			



Lug Extrusion



C 21109/01

Location	Loc Qty	Loc Code
MAT006	538.5	
43722	161.5	
45800	1	
68331	376	

4.11

D3910-3P

X 30

Rec'd 9/12 (30)

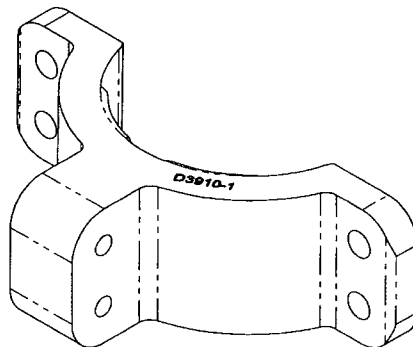
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

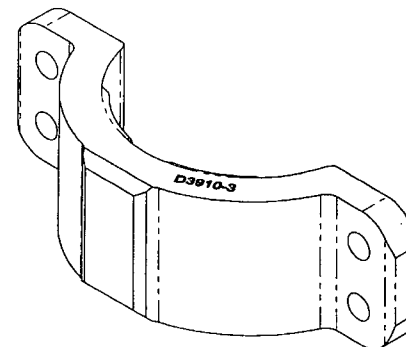
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D3910-1 X-TUBE LUG







D3910-3 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

W1073526

RELEASED
2010-03-22
MP

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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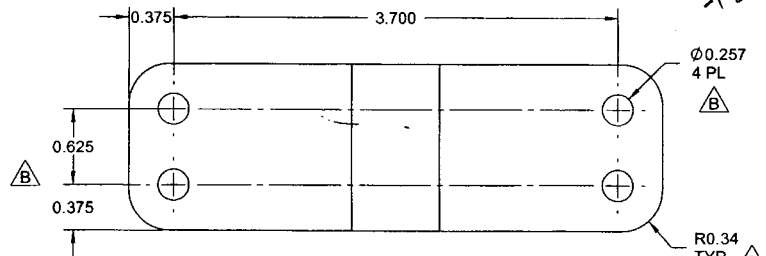
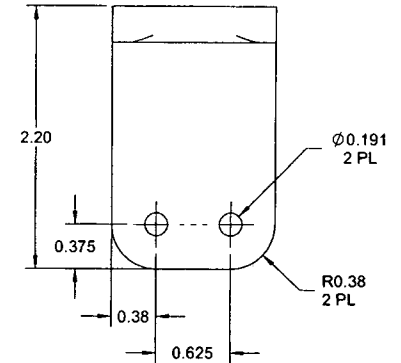
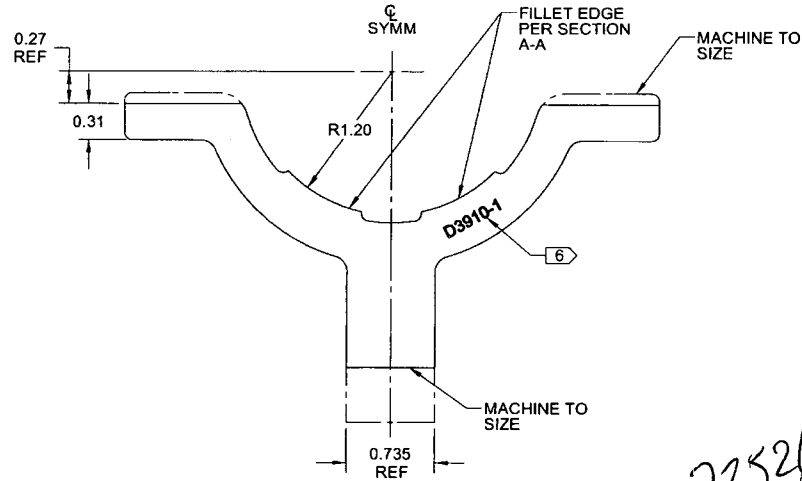
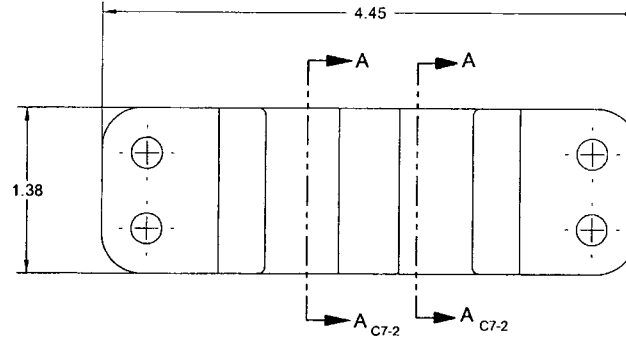
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ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL




SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG

23526

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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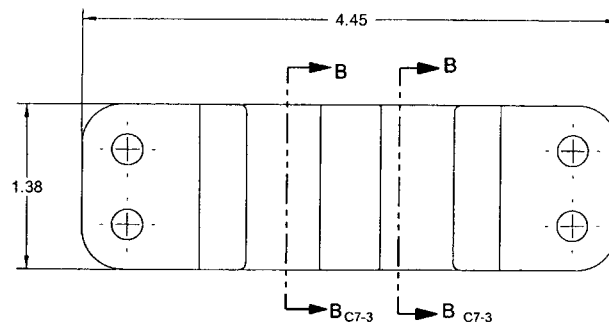
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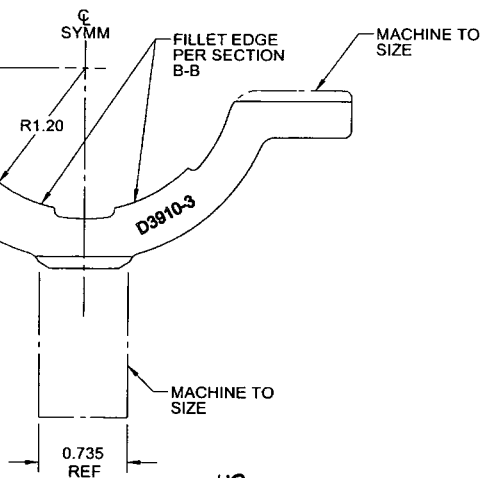
ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3

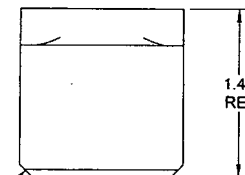


0.27
REF

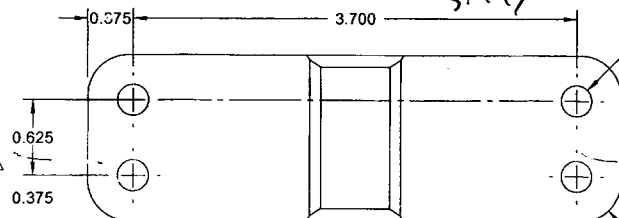
0.31



0.100 X 45° CMF
TYP



368
B





Ø0.257
4 PL
B

B
R0.34
TYP

D3910-3 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3910	REV. B SHEET 3 OF 3
MFG. APPR.		TITLE X-TUBE LUG (350)	SCALE NTS
APPROVED		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DE APPR.			
DATE	10.03.16		

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NOTE: Date & initial all entries



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.:

Date:

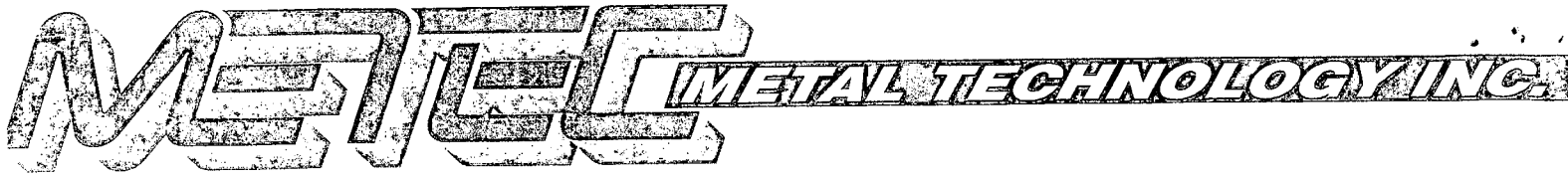
Sep 12, 2011

Page:

1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14799	Sold By: Walz, Christian D.
Shipped By:	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	80		80
D2230-1 Mounting Lug Material supplied by DART: D2423 B68331	Each	100		100
D2230-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	200		200
D3235-1 Mounting Lug Material supplied by DART: D2423 B68331	Each	100		100
D3394-1 Lug Assembly Material supplied by DART: D2423 B68331	Each	40	40	
D3910-1 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30	30	
3910-3 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30	30	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

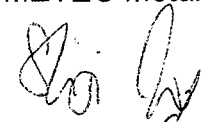
<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3394-1P	Lug	14799
30	D3910-1P	CROSS TUBE LUG	14799
30	D3910-3P	CROSS TUBE LUG	14799

MATERIAL: supplied by DART D2423 B63005

8/10/12

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, Sept. 12, 2011